



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D5737-3
Job Sheet 203345

Accounting Job RD19-1069-01



Part No: D5737-3

Job Qty: 1 pcs

Part Name: MID Weaplate



Part Weight: 0 lbs

Status: New

Job Created: 11/15/19

Job Tracking No:

Due Date: 11/29/19

Created By: Marie Lajeunesse

Type: R+D

Description:

Note: URF 19-1208 DWG D5737 Rev.A IPP Rev. A 19.11.11 New issue DP Verify DD

Ship Via:

POSITIVE RECALLEFFECTIVE 19/11/19 AUTH *ve*

DAS

RELEASED 9 DATE 19-11-26

9-89 Priority: Medium

Bill of Materials**Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	1 pcs	11/29/19	11/29/19	0.17	0.25	Waterjet - Flow		<i>SRB 11/20/19</i>
110	QC 2	1 pcs	11/29/19	11/29/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
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Email: sales@dartero.com
www.dartaerospace.com



Container No: S233486

Part: D5737-3

Job No: 203345

Serial No/Batch: S233486

Revision: U/R Rev A

Inspector:

Exp Date:

Instructions:

Date: 11/20/19

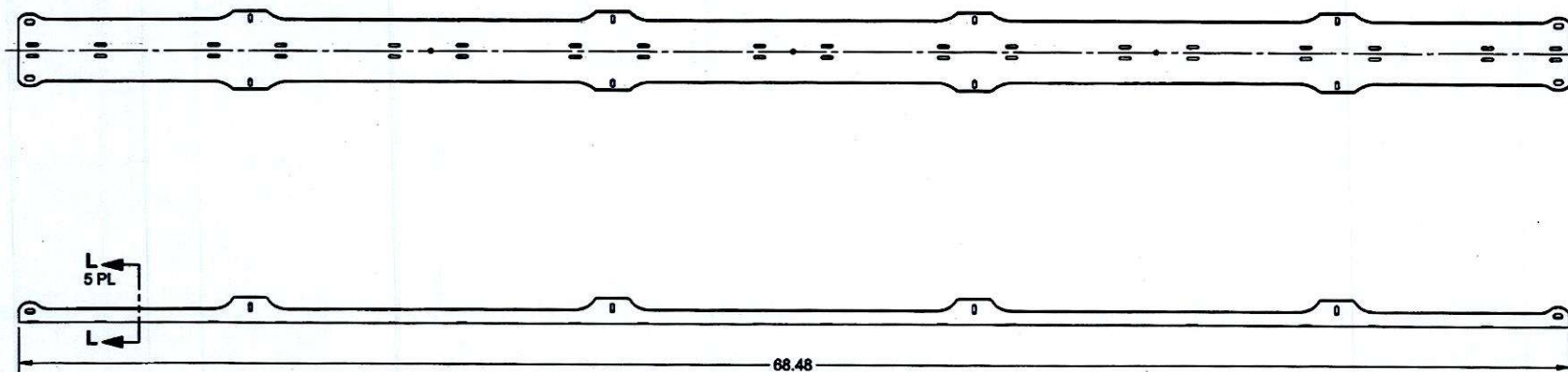
Plex 11/15/19 11:08 AM Dart.lajeunesse.marie

120 QC 8	1 pcs	11/29/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	JRB 11/20/19
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	NOV 20 2019
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
130 Small Fab - Brake NC - B4B	1 pcs	11/29/19	0.25 0.17	Small Fab - Brake - 1 - B4B	DAS 30 NOV 22 2019
				Small Fab - Brake - 2 - B4B	9-89
				Small Fab - Brake - 3 - B4B	
140 QC 5	1 pcs	11/29/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
150 Packaging 3-1 - Stock - B4B	1 pcs	11/29/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	

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 DAS 9 9-89 ok to release	Packaging 3 - 4 - B4B			
	Packaging 3 - 5 - B4B			
	Packaging 3 - 6 - B4B			
	Packaging 3 - 7 - B4B			
	Packaging 3 - 8 - B4B			
	Packaging 3 - 9 - B4B			
	Packaging 3 - 10 - B4B			
	Packaging 3 - 11 - B4B	CL		
	Packaging 3 - 12 - B4B			
	Packaging 3 - 13 - B4B			
	Packaging 3 - 14 - B4B			
	Packaging 3 - 15 - B4B			
	Packaging 3 - 16 - B4B			
	Packaging 3 - 17 - B4B			
	Packaging 3 - 18 - B4B			
	Packaging 3 - 19 - B4B			
	Packaging 3 - 20 - B4B			
	Packaging 3 - 21 - B4B			
	Packaging 3 - 22 - B4B			
	Packaging 3 - 23 - B4B			
	Packaging 3 - 24 - B4B			
	Packaging 3 - 25 - B4B			
	Packaging 3 - 26 - B4B			
	Packaging 3 - 27 - B4B			
	Packaging 3 - 28 - B4B			
	Packaging 3 - 29 - B4B			
	Packaging 3 - 30 - B4B			
	Packaging 3 - 31 - B4B			
	Packaging 3 - 32 - B4B			
	Packaging 3 - 33 - B4B			
	Packaging 3 - 34 - B4B			
	Packaging 3 - 35 - B4B			
	Packaging 3 - 36 - B4B			
	160 QC 21 - SA	1 pcs	11/29/19 0.00 0.00	
			QC 21 - SA - 21	
			QC 21 - SA - 70	
		QC 21 - SA - 53		
Part Op 100 - 1-Cut DSK194-3F as per dwg prog rev: <u>A</u> dwg rev: <u>A</u> 2-Deburr if required Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB 120 - QC8- Inspect parts - second check 130 - Form as per dwg D5737 140 - QC5- Inspect part completeness to step on W/O 150 - Identify as per dwg & Stock Location: <u>W/O</u> 160 - QC21- Final Inspection - Work Order Release				
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	1.7700 sf (1.77 ea)	100-Waterjet - Flow - 1	5251058
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	2	266	0
Part Specifications				
Specifications could not be found.				

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D5737-3 MID WEARPLATE

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 203345

UNDER REVIEW

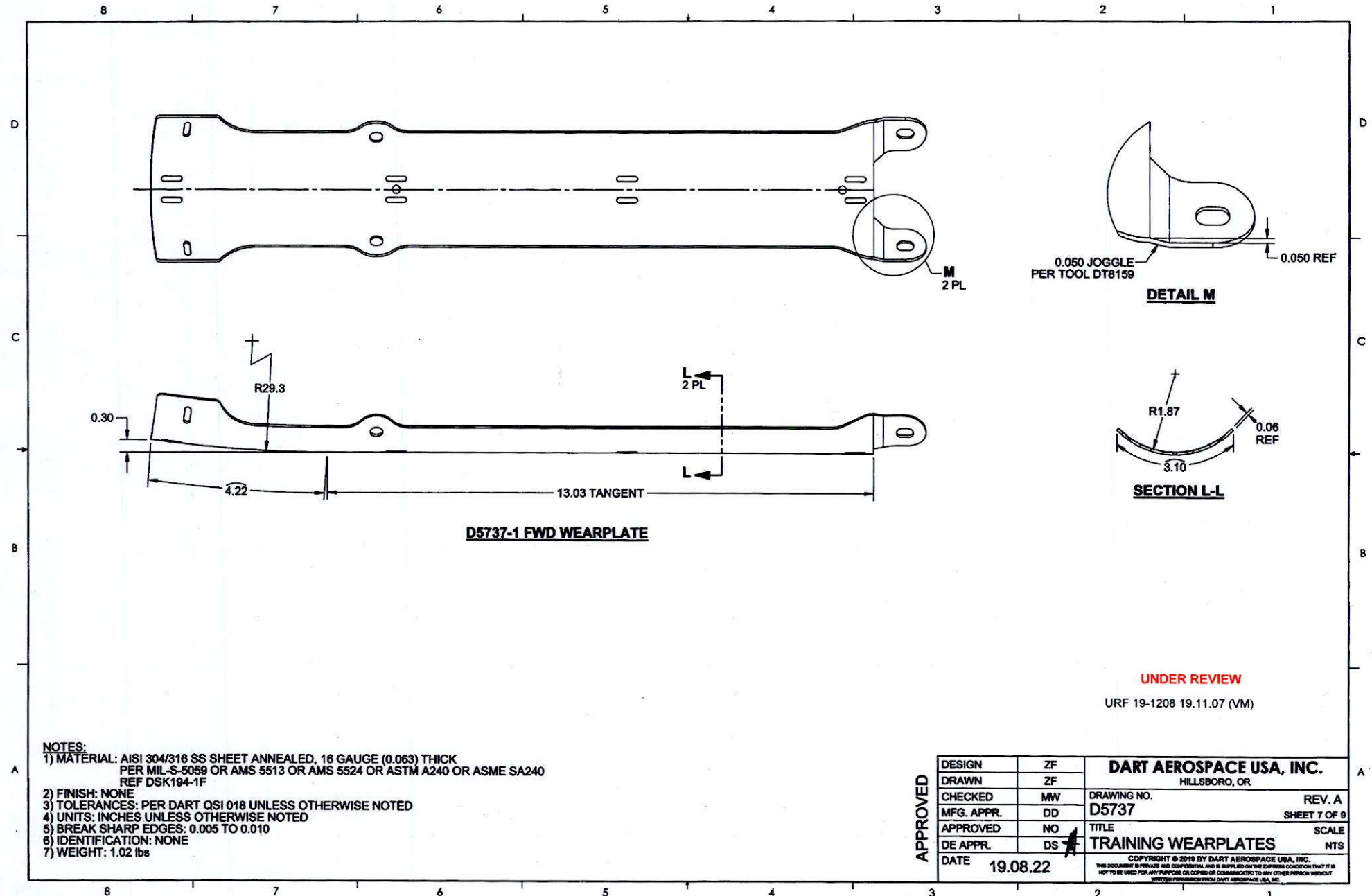
URF 19-1208 19.11.07 (VM)

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED, 16 GAUGE (0.063) THICK
PER MIL-S-5069 OR AMS 5513 OR AMS 5524 OR ASTM A240 OR ASME SA240
REF DSK194-3F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 3.88 lbs

APPROVED

DESIGN	ZF	DART AEROSPACE USA, INC. HILLSBORO, OR	
DRAWN	ZF		
CHECKED	MW	DRAWING NO.	REV. A
MFG. APPR.	DD	D5737	SHEET 8 OF 9
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	TRAINING WEARPLATES	NTS
DATE	19.08.22	COPYRIGHT © 2019 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCIAL OR GOVERNMENT SERVICE WITHOUT PERMISSION FROM DART AEROSPACE USA, INC.	



APPROVED	DESIGN	ZF	DART AEROSPACE USA, INC. HILLSBORO, OR	
	DRAWN	ZF		
	CHECKED	MW	DRAWING NO.	REV. A
	MFG. APPR.	DD	D5737	SHEET 7 OF 9
	APPROVED	NO	TITLE	SCALE
	DE APPR.	DS	TRAINING WEARPLATES	NTS
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD		Work Order:	203345
Description: MID Wearplate		Part Number:	DSK 194-3
Inspection Dwg: DSK194	Rev: A	Page 1 of 2	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.400	+/- 0.010	0.402				
R0.50	+/- 0.030	R0.50				
0.300	+/- 0.010	0.303				
R0.13	+/- 0.030	R0.13				
1.36	+/- 0.030	1.37				
0.60	+/- 0.030	0.61				
R1.00	+/- 0.030	R1.00				
0.15	+/- 0.030	0.15				
R0.08	+/- 0.030	R0.08				
0.50	+/- 0.030	0.52				
0.13	+/- 0.030	0.13				
0.50	+/- 0.030	0.51				
0.19	+/- 0.030	0.18				
0.38	+/- 0.030	0.39				
R0.06	+/- 0.030	R0.06				
2.410	+/- 0.010	2.410 2.410				
1.205	+/- 0.010	1.206				
0.70	+/- 0.030	0.70				
0.188	+/- 0.005/-0.001	0.190				
67.080	+/- 0.010	67.080				
68.48	+/- 0.30	68.52				
1.38	+/- 0.030	1.38				
2.75	+/- 0.030	2.75				
4.25	+/- 0.030	4.27				
2.13	+/- 0.030	2.15				
3.00	+/- 0.030	3.00				
1.50	+/- 0.030	1.52				
1.855	+/- 0.010	1.855				
3.710	+/- 0.010	3.712				

Measured by:	Checked by:	QC Inspector:
Date:	Date:	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

DART AEROSPACE LTD		Work Order:	
Description:		Part Number:	
Inspection Dwg:	Rev:	Page 2 of 2	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
67.61	+/- 0.030	67.61			JRB-01V	
64.61	+/- 0.030	64.61			JRB-02V	
59.62	+/- 0.030	59.62			Tape	
58.16	+/- 0.030	58.16				
56.62	+/- 0.030	56.62				
51.62	+/- 0.030	51.62				
50.24	+/- 0.030	50.24				
48.62	+/- 0.030	48.62				
43.62	+/- 0.030	43.62				
42.16	+/- 0.030	42.16				
40.62	+/- 0.030	40.62				
35.49	+/- 0.030	35.49				
34.24	+/- 0.030	34.24				
32.49	+/- 0.030	32.49				
27.37	+/- 0.030	27.37				
26.18	+/- 0.030	26.18				
24.37	+/- 0.030	24.37				
19.37	+/- 0.030	19.37				
18.24	+/- 0.030	18.24				
16.37	+/- 0.030	16.35				
11.37	+/- 0.030	11.39				
10.18	+/- 0.030	10.19				
8.37	+/- 0.030	8.36				
3.38	+/- 0.030	3.38				
0.38	+/- 0.030	0.39				

Measured by: JRB	Checked by: RD	QC Inspector:
Date: 11/20/19	Date: 19.12.10	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	